

Claims:

- 5 1. Process for joining the ends of hollow section strip(s) (1) or the ends of a hollow section strip which has been bent into a frame, by welding, in which the end faces (5) of the ends of the hollow section strip(s) (1) are placed next to one another and during the welding process are moved towards one another, characterized in that before
10 executing the welding process on at least one surface (2) of the ends of the hollow section strip(s) (1) to be joined to one another an edge (7) is produced which extends over the width of the surface (2) and which is set back relative to the end faces (5) of the ends of the
15 hollow section strip(s) (1).
- 20 2. Process as claimed in claim 1, wherein the surfaces (2) on the ends of the hollow section strip(s) (1) on which the edges (7) are produced are surfaces (2) of the hollow section strip(s) (1) pointing to the outside.
- 25 3. Process as claimed in claim 1 or 2, wherein the ends of the hollow section strip(s) (1) are moved so close to one another during the welding process that the edges (7) touch one another.
- 30 4. Process as claimed in one of claims 1 to 3, wherein the edges (7) are produced by machining at least one wall of the hollow section strip(s) (1).
- 35 5. Process as claimed in one of claims 1 to 4, wherein in at least one wall of the hollow section strip(s) (1) steps (6) are produced to form the edges (7) which are set back relative to the end faces (5).
6. Process as claimed in one of claims 1 to 4, wherein in at least one wall of the hollow section strip(s) (1) grooves (11) are produced to form the edges (7) which are set back relative to the end faces (5).

FIG. 1

Sub A1

- add B18